

Date: Wednesday, 3/12/2008 1:41:47 PM
 User: Kim Johnston

Process Sheet

116
86
208

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CLAMP
 Job Number : 37852
 Estimate Number : 10267
 P.O. Number :
 This Issue : 3/12/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D2438
 First Issue : 1 / Drawing Number : D2438 REV. C
 Previous Run : 37562 Type : PURCHASED PARTS Project Number : N/A
 Drawing Revision : C
 Material :
 Due Date : 4/10/2008 Qty: 200 Um: Each
 Written By :
 Checked & Approved By : 08 03 12
 Comment : Est: E 05.06.28 Bending removed KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 5909

Laser cut as per Dwg D2438

Material release note is required

CFI

C 0803/13

(200)

2.0 D2438B Clamp



Comment: Qty.: 1.0000 Each(s)/Unit Total : 200.0000 Each(s)

CLAMP

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

Pa 8/4/20

(200)

4.0 QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D2438

(6.786" center to center)

QSP019

208/04/11

counts

(x 200)

5.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Counted

Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble & Deburr any rough edges

Pa 08/04/21

(200)

08/04/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/12/2008 1:41:47 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 37852

Part Number: D2438

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Is 009



counts

Comment: INSPECT WORK TO CURRENT STEP

80064/21

4700

7.0

PACKAGING 1

PACKAGING RESOURCE #1



200x

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8/4/22

SP

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/22

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08-04-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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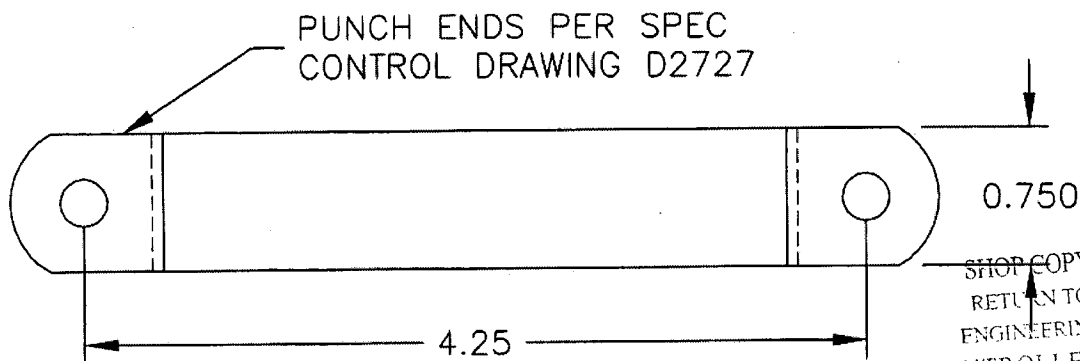
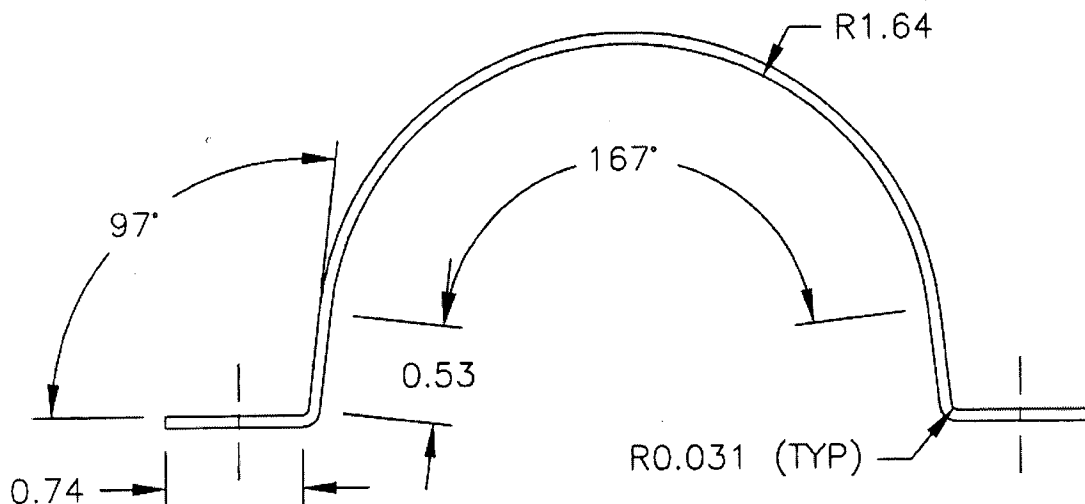
NOTE: Date & initial all entries

DART



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MD</i>	APPROVED <i>KE</i>	DRAWING NO. D2438	REV. C SHEET 1 OF 1
DATE 98.05.12		TITLE CLAMP	SCALE 1:1
A	96.01.24	NEW ISSUE	
B	96.05.13	CHANGE LENGTH	
C	98.05.12	R1.64 WAS R1.438, CHANGE GEOMETRY	

RELEASED
98.06.17 KE



FLAT LENGTH: 7.586 END-END
6.786 HOLE-HOLE

MATERIAL: AISI 304/316 SS 0.063 THICK
MINIMUM REQUIREMENT IS ANNEALED CONDITION

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **37852**

00.06.06
CP 00.06.07

5.047



180 AVENUE LABROSSE
POINTE-CLAIRE, QUÉ., CANADA H9R 1A1
TÉL.: (514) 630-4877 - FAX: (514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.

VENDEUR / SOLD TO



BON DE LIVRAISON - SHIPPING MEMO

DATE DE LIVRAISON SHIPPING DATE	N° BON DE LIVRAISON SHIPPING MEMO NO.
2008/04/08	0390425

EXPÉDIÉ À / SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7

CODE DE CLIENT CUSTOMER CODE		N° DE CONTRAT JOB NO.	N° COMMANDE PO NO.
DART GFI-0299		J0179358	PO00005909
QUANTITÉ QUANTITY	VOTRE N° DE PIÈCE YOUR PART NO.	DESCRIPTION	
200	D2438B	CLAMP CUT&FORMED CERTIFICATE OF CONFORMANCE REQ	

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RECEPTION DES BIENS.
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

RECU PAR / RECEIVED BY

**CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE**



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. 16 OUR JOB NO J0179358 SHIPPING MEMO 0390425

ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
--	<u>200 PCS</u>	<u>PO00005909</u>	<u>D2438B</u>	<u>C</u>	<u>CLAMP</u>	<u>C</u>

MATERIAL S.S.T 304 SUPPLIED BY TW METALS / NORTH AMERICAN MAT. REL. NO. 2MW9

	PROCESS	PROCESSOR	RELEASE NOTE #
1	<u>FIRST ARTICLE INSPECTION REPORT ON FILE</u>	<u>GFI</u>	<u>CONFORMS</u>
2			
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 09 APRIL 2008

G.F.I. Q.C. REP. *Carroll H. Smith*

~~SP12-091 REV 0 Bombardier Certificate of Compliance~~
~~TW Metals District Procedure~~

Revision: 0

Revision Date: 04-03-00

Superseding: Initial

Page: 1 of 1

CERTIFICATE OF COMPLIANCE

~~FRAUD AND FALSIFICATION STATEMENT~~

~~The recording of false, fictitious, or fraudulent statements or entries on this document may be punished as a felony under federal statutes including federal law, Title 18 chapter 47.~~

CERTIFICATE OF COMPLIANCE

This certificate of compliance certifies that the material supplied on the purchase order number below complies in all respects with the material description and procurement specifications.

MERCURY FREE STATEMENT

We certify that mercury, radium, or alpha bearing instruments and / or equipment which might cause contamination have not been used in the manufacture, fabrication, assembly or testing of any material supplied by TW Metals Inc. Switches, glass thermometers, standard cell and other items containing the above elements may be used, but they will be located so as not to constitute a contamination hazard.

CUSTOMER NAME: GET

PURCHASE ORDER No. 0073225

ITEM No. 0001

SHIPPER INVOICE No. 03232573

MATERIAL: 304-2B

SPECIFICATION: ASTM A262

MANUFACTURING MILL: North American Stainless

SIZE: 062

HEAT / LOT No. 2mw9

PART No. TS06348X964A

QUANTITY: 125-43218

TEST DEPARTMENT CLERK: Jessie Clark

AUTHORITY

Joe Schab

Director of Quality Assurance

This document is maintained as a Controlled Document only in the TW Metals computer system. Once printed, this document immediately becomes Uncontrolled and is subject to change at any time and without notice.

49189775

NORTH AMERICAN
STAINLESS

METALLURGICAL TEST REPORT

6870 Highway 42 East
Ghent, KY 41045-9615
(502) 347-6000

Certificate: 366147 02. Mail To:

Ship To:

Customer: 0018 001

Date: 7/11/2007

Page: 1

Steel: 302/304/304L

Finish: 2B

Your Order: 01010133

NAS Order: AN 0373673 01

Corrosion: ASTM A262/C2aE; 180Rand-OK

PRODUCT DESCRIPTION:

STAINLESS STEEL COIL, COLD ROLLED, ANNEALED AND PICKLED.
ASTM A240/06b, 480/06b, 666/03, ASME SA240/04-A05, 480/04-A05, SA666/04
Q08766D-AXMG PRM, AMS 5511B/5513H/5516P, AMS 03, X CRWN MEAS

REMARKS:

Mat'l Free of Mercury Contamination. No weld repairs.
EN 10204 3.1; Q08763P Cond A; RoHS Compliant
* Melted & Manufactured in the USA

Product ID #	Coil #	Thickness	Width	Weight	Length	Mark	Pieces	COMMODITY CODE
022MW9 A	* 022MW9 A	.0620	36.0000	20,700 COIL	2778.9	11	1	

CHEMICAL ANALYSIS

Heat	CM	C	CR	CU	MN	MO	N	NI	P	S	SI
2MW9	US	.025	18.329	.298	1.832	.311	.072	8.113	.026	< .001	.332

MECHANICAL PROPERTIES

Product ID #	Coil #	1 d o i c r	UTS KSI	.2% YS KSI	ELONG 1/2"-2"	Hard RB	Tail Hard	Grain No.
022MW9 A	022MW9	F T	95.50	48.52	48.03	86.50	82.50	8.000

TW METALS

TEST

MAR 12 2008

ACCEPTED BY

REVIEWED BY Q.C.

Date 7/13/07 by

NAS hereby certifies that the analysis on this certification is correct and the material meets the specifications stated.

QC ENGINEER

ERIC HESS

7/11/2007

Size: 304/L ANH .050-.056 AMS 5513/11
Customer: TW Metals-Cincinnati
Heat: 2MW9
Sales: 01106395
Shipped: 02/29/08 49189775
36 X 96
P.O.: 070302-7
QTY: 8